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SIR:

Transmitted herewith for filing is the utility patent
application of: **GREGORY S. ANTOUN**

for: **PROGRAMMABLE, VARIABLE VOLUME AND PRESSURE, COOLANT SYSTEM**

Enclosed Are:

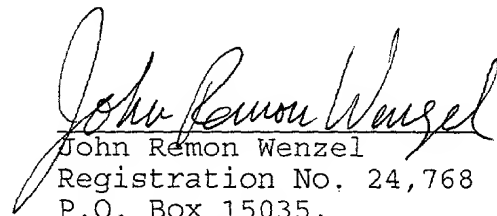
1. Patent Application, 17 sheets
2. 5 sheets of Formal Drawings Containing 5 Figures
3. Combined Declaration and Power of Attorney, 2 sheets
4. Verified Statement Claiming Small Entity Status, 1 sheet
5. Information Disclosure Statement
6. Associate Power of Attorney, 1 sheet
7. Form PTO-1449, with copies of 4 references
8. Filing Fee in the Amount of \$385.00

The filing fee has been calculated as shown below:

BASIC FEE	SMALL ENTITY	\$385.00
TOTAL CLAIMS	(13 - 20 = 0) x 11	0.00
IND. CLAIMS	(2 - 3 = 0) x 40	<u>0.00</u>
TOTAL		<u>\$385.00</u>

Additional fees due, if any, may be charged to Deposit Account
No. 12-1662 of the undersigned.

Respectfully Submitted,


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IN THE APPLICATION

OF

GREGORY S. ANTOUN

FOR A

PROGRAMMABLE, VARIABLE VOLUME AND PRESSURE, COOLANT SYSTEM

PROGRAMMABLE, VARIABLE VOLUME AND PRESSURE, COOLANT SYSTEM

BACKGROUND OF THE INVENTION

1. FIELD OF THE INVENTION

5 The present invention relates to a system for varying the volume and pressure of a coolant produced within machining and cutting tools and, more specifically, to a control system that regulates the speed of a coolant pump based on sensed coolant pressure, and the size of a coolant delivery orifice.

2. DESCRIPTION OF THE RELATED ART

10 Many types of cutting tools require that coolant (and/or lubricant) be delivered directly to the surface being cut. These fluid cooled tools include but are not limited to: drill presses; end mills; routers; and milling cutters. In prior art devices pressurized coolant is supplied by a single speed pump, and
15 pressure control (required due to varying coolant flow requirements during machine processes) is accomplished using pressure relief valves and/or excess coolant is simply allowed to flow through the tool, filter and return lines. These pressure control methods result in reduced filter and pump life, increased heat and foam,
20 and higher energy costs. By controlling the pump motor speed, the present invention overcomes these drawbacks. U.S. Patent No.

5,028,176, issued on July 2, 1991 to Delventhal et al., discloses a glass drilling machine having a pressure transducer for monitoring cooling fluid back pressure and a regulator for controlling the position of a drill bit based on this back pressure. U.S. Patent No. 5,559,713 issued on September 24, 1996 to Brown et al., discloses a chip buildup detection and control system, including a computer, for monitoring coolant flow to the cutter of a machine tool and controlling the machining operation and coolant flow. A flow transducer is used to control coolant flow from a high pressure pump. U.S. Patent No. 5,601,414, issued on February 11, 1997 to DiRe, discloses a programmable logic controller that monitors a fluid pressure and controls a pump motor to regulate pressure within the pump, under abnormal fluctuations. The use of this device to control coolant flow, is not disclosed. British Patent Application No. 2,010,137 (Martin), published on June 27, 1979, discloses a machine tool coolant distribution system that delivers coolant only to those tools in the working position. Control of the pump motor speed is not discussed.

None of the above inventions and patents, taken either singularly or in combination, is seen to describe the instant invention as claimed. Thus a programmable, variable volume and pressure, coolant system solving the aforementioned problems is desired.

SUMMARY OF THE INVENTION

The present invention is directed toward a more efficient method of regulating the amount of coolant flow to a cutting tool in order to compensate for variations in coolant flow requirements.

5 These variations are caused by orifices that may be valved closed, the position of tool relative to surface, etc., machines being on or off, temperature, etc. The coolant flow is regulated in the present invention, by controlling the speed of a coolant pump. The programmable, variable volume and pressure, coolant supply system
10 is comprised of a fluid control unit and an electrical control panel. The fluid control unit includes a pump and a AC pump motor operatively connected thereto. The electrical control panel includes: a power supply; circuit breakers; a computer; a variable frequency drive; control relays; and a junction block for making
15 electrical connections to the control panel.

The computer receives signals from the tool and a pressure transducer, and is programmed with information concerning the total flow area of the coolant orifice(s). Using the programmed information, the pressure signal, and any monitoring signals
20 provided by the tool (which orifices may be valved closed, position of tool relative to surface, etc.), the computer determines an ideal pump speed, and sends a control signal to the variable frequency drive. The control signal sets the frequency of the drive, which in turn determines the pump motor speed.

The coolant supply system also includes: a coolant supply line for routing coolant from the pump to the tool; a catch pan for collecting recycled coolant from the tool; a filter for removing impurities from the used coolant; a reservoir for storing coolant, and a return line for routing the recycled coolant to the reservoir and from the reservoir to the pump inlet. In tools that do not recycle coolant, the catch pan, filter and return line from the tool to the reservoir may be eliminated.

The electrical control panel is connected to the tool and the fluid control unit by electrical control wires. The control wires allow the coolant supply system to be programmed at the tool's control panel, and also connect the internal pressure transducer to the electrical panel. The transducer is located in the supply line, preferably close to or in the tool. The control wires also provide the control signals for the pump and other devices in the fluid control unit that are sent by the electrical panel.

The programmable, variable volume and pressure, coolant supply system of the present invention can also be used to supply coolant to more than one fluid cooled tool, with each tool having one or more coolant orifices. In such a case, the computer is provided with each tool's coolant pressure requirements (instantaneous orifice(s) total flow area, machine on or off, temperature, etc.). While the coolant supply system is self correcting, (a difference between the measured and desired coolant pressure, resulting in an increase or decrease of pump motor speed) by providing the computer with each tool's coolant pressure requirements, the computer can

anticipate pressure fluctuations and react by adjusting the pump motor speed prior to the fluctuations occurring.

Accordingly, it is a principal object of the invention to regulate coolant flow in a fluid cooled tool by controlling the speed of a coolant pump motor.

It is another object of the invention to minimize coolant and energy losses in a coolant system by pumping only the necessary amount of coolant through the system.

It is a further object of the invention to increase filter and pump life in a coolant supply system.

It is an object of the invention to provide improved elements and arrangements thereof in a programmable, variable volume and pressure, coolant system for the purposes described which is inexpensive, dependable and fully effective in accomplishing its intended purposes.

These and other objects of the present invention will become readily apparent upon further review of the following specification and drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 is an environmental view of the programmable, variable volume and pressure, coolant system of the present invention, connected to a fluid cooled tool.

Figure 2 is a perspective view of the electrical control panel used in the programmable, variable volume and pressure, coolant system of the present invention.

5 Figure 3 is a perspective view of the fluid control unit used in the programmable, variable volume and pressure, coolant system of the present invention.

Figure 4 is a schematic diagram of the coolant system of the present invention.

10 Figure 5 is a close-up perspective view of a prior art, fluid cooled tool showing a typical coolant orifice therein.

Similar reference characters denote corresponding features consistently throughout the attached drawings.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

15 The present invention is a programmable, variable volume and pressure, coolant supply system. This system is shown supplying coolant to a tool 100 in figure 1. The coolant supply system is comprised of two basic components, a fluid control unit 101, and an electrical panel 102. Coolant from the fluid control unit 101 is routed to the tool 100 by a coolant supply line 103. After cooling
20 the tool 100, the coolant is collected by a catch pan 104, and routed back to the fluid control unit 101 by a coolant return line 105. A filter 106 for removing filings from the coolant may be formed integrally with the catch pan 104, or alternatively may be placed in the coolant return line 105. The electrical panel 102 is

connected to the tool 100 and the fluid control unit 101, by electrical control wires 107 and 108, respectively. Control wires 107 allow the coolant supply system to be programmed at the tool's control panel 109. If it is desired to monitor coolant pressure directly at the tool, control wires 107 also connect the internal pressure transducer to the electrical panel 102. Control wires 108 provide the control signals for the pump and other devices in the fluid control unit 101 from the electrical panel 102. In addition, when coolant pressure is monitored at the pump's output, control wires 108 also connect the pressure transducer to the electrical panel 102.

Details of the electrical panel 102 are shown in figure 2. The power supply and the power supply transformer 200 provide the necessary operating voltages for the various components of the electrical control system. Circuit breakers 201 protect the electrical panel 102 from excess current flow. Computer 202 receives the signals from the pressure transducer and is programmed with information concerning tool 100. This information includes the number of coolant orifices in the tool 100 and the total flow area of these orifices. Using the programmed information, the pressure signal, and any monitoring signals provided by the tool (which orifices may be valved closed, position of tool relative to surface, etc.) The computer 202 determines an ideal pump speed, and sends control signals to the variable frequency drive 203. The electrical panel 102 also includes a number of control relays 204,

and a junction block 205 for connecting electrical control wires 107 and 108 to the electrical panel 102.

The main components of the fluid control unit 101 are shown in figure 3. These include a pump 300 having a number of inlets 301 and a number of outlets 302, and a pump motor 304. The pump motor 304 is an AC synchronous motor and is either single phase or three phase. In AC synchronous motors, the frequency of the AC voltage supplied to the motor determines the speed of the motor. For example a motor that turns at 1714 RPM at 60Hz will turn at 857 RPM at 30Hz (neglecting slippage caused by torque and inherent motor characteristics). The motor 304 has a drive shaft with a driving pulley 305 mounted thereon. The driving pulley 305 is operatively connected by drive belt 306 to driven pulley 307 on the input shaft of pump 300. The inherent characteristics of the fluid control unit 101 are programmed into the computer 202. The only critical relationship that the computer needs to be programmed with, however, is the frequency required to drive the pump at a speed that results in the desired coolant pressure. The pump 300, the pump motor 304, and the smaller components (not shown) of the fluid control unit 101, are all mounted to support plate 303. Support plate 303 is mounted using anti-vibration bushings to reduce vibrations transmitted to the tool 100.

A schematic representation of the programmable, variable volume and pressure, coolant supply system is shown in figure 4. The operation of the coolant supply system is as follows. A coolant reservoir 400, supplies coolant to the inlet of pump 300

via return line 105. Pump 300 is driven by pump motor 304, and delivers pressurized fluid to the fluid cooled tool 100 via supply line 103. A pressure transducer 401 sends a signal proportional to coolant pressure to the computer 202 in the electrical panel 102 via line 402. The transducer 401 can be mounted at any point in the supply line 103, but is preferably mounted in the tool 100 itself. The coolant travels through the cooling orifice(s) in the tool 100 and at least part of the coolant is captured by catch pan 104. As the cutting operation creates filings from the material being machined, a filter 106 is provided to remove any impurities from the coolant. Filter 106 is shown mounted in the catch pan 104, however, it may be mounted at any location between the catch pan 104 and the reservoir 400. Some coolant systems do not recycle the coolant. When the present invention is used with these type systems, the catch pan and return line are eliminated.

The computer 202 determines a drive frequency based on the flow area of the coolant orifice(s) in the tool 100. In figure 5, a typical tool (drill bit) A with a coolant orifice C is shown. Coolant enters the drill bit A at point B, and exits at the coolant orifice C. For a circular orifice having a diameter D, such as the one shown, the flow area, A_f is $D \times \pi$. Coolant flow through the orifice is $(P_t - P_a) \times A_f$. Where P_t is the coolant pressure measured by the transducer, and P_a is atmospheric pressure. Of course, these equations are only shown for background information, and the actual desired pressure is determined by experimentation. As the coolant requirements for the tool 100 change, (due to machining

processes, etc.) the desired pressure also changes, and by providing the computer 202 with information concerning these processes, changes in the coolant requirements can be accounted for. Once a desired pressure is determined, the computer 202 provides a signal proportional to a desired associated frequency, to the variable frequency drive 203. The computer 202 can use feedback from the pressure transducer 401 to "hunt" for the desired pressure by increasing and decreasing the frequency and the resulting pump speed.

The programmable, variable volume and pressure, coolant supply system of the present invention can be used to supply coolant to more than one fluid cooled tool, with each tool having one or more coolant orifices. By providing the computer 202 with each tool's coolant pressure requirements (instantaneous orifice(s) total flow area, machine on or off, temperature, etc.) the computer can anticipate pressure fluctuations and react by controlling the pump motor speed.

It is to be understood that the present invention is not limited to the embodiment described above, but encompasses any and all embodiments within the scope of the following claims.

CLAIMS

I claim:

- 1 1. A programmable, variable volume and pressure, coolant
2 supply system comprising:
3 at least one fluid pressure transducer for monitoring coolant
4 pressure;
5 a pump for providing coolant to at least one tool with at
6 least one coolant orifice means, the orifice means having a flow
7 area;
8 an electrical AC pump motor operatively connected to said
9 pump;
10 a variable frequency drive electrically connected to said pump
11 motor, said variable frequency drive providing AC power to said
12 pump motor at various frequencies, to thereby control a speed of
13 said pump motor; and
14 a computer, said computer monitoring the coolant pressure via
15 said at least one fluid pressure transducer and being programmed
16 with data related to the flow area of the orifice means; and
17 wherein
18 said computer determines a desired speed of said pump motor
19 based on the coolant pressure and the flow area of the orifice
20 means of the tool;

21 said computer controlling the variable frequency drive to
22 provide said pump motor with AC power at a frequency that results
23 in said pump motor running at the desired speed.

1 2. The coolant supply system as defined in claim 1, further
2 comprising a coolant supply line, said coolant supply line
3 extending between said pump outlet and the orifice means, to supply
4 said coolant under pressure to the orifice means.

1 3. The coolant supply system as defined in claim 2, further
2 comprising a coolant return line, said coolant return line
3 extending between the tool and said pump inlet, for returning said
4 coolant to said pump inlet after said coolant exits the orifice
5 means.

1 4. The coolant supply system as defined in claim 3, further
2 comprising a coolant reservoir in said coolant return line.

1 5. The coolant supply system as defined in claim 4, further
2 comprising a coolant catch pan between the tool and said coolant
3 return line, said coolant catch pan receiving said coolant exiting
4 the orifice means and directing it into said coolant return line.

1 6. The coolant supply system as defined in claim 5, further
2 comprising a coolant filter in said catch pan, to remove impurities
3 from said coolant exiting the orifice means prior to directing said
4 coolant into said coolant return line.

1 7. A fluid cooled, cutting tool system comprising at least
2 one cutting tool having a coolant orifice means with a flow area
3 for applying a coolant to said at least one tool, and a
4 programmable, variable volume and pressure, coolant supply system,
5 said coolant supply system comprising:

6 at least one fluid pressure transducer for monitoring the
7 pressure of said coolant;

8 a pump having an inlet and an outlet, for providing
9 pressurized coolant to said coolant orifice means;

10 an electrical AC pump motor operatively connected to said
11 pump;

12 a variable frequency drive electrically connected to said pump
13 motor, said variable frequency drive providing AC power to said
14 pump motor at various frequencies, to thereby control a speed of
15 said pump motor; and

16 a computer, said computer monitoring said coolant pressure via
17 said at least one pressure transducer, and being programmed with
18 data related to said flow area of said coolant orifice means; and
19 wherein

20 said computer determines a desired speed of said pump motor
21 based on said coolant pressure and said flow area of said orifice
22 means;

23 said computer controlling said variable frequency drive to
24 provide said pump motor with AC power at a frequency that results
25 in said pump motor running at said desired speed.

1 8. The fluid cooled, cutting tool system as defined in claim
2 7, wherein:

3 said coolant orifice means includes a plurality of orifices;

4 said flow area is a total flow area of said plurality of
5 orifices; and

6 said computer determines said desired speed of said pump motor
7 based on said coolant pressure and said total flow area of the
8 plurality of orifices.

1 9. The fluid cooled, cutting tool system as defined in claim
2 8, further comprising a coolant supply line, said coolant supply
3 line extending between said pump outlet and said orifice means, to
4 supply said coolant under pressure to said orifice means.

1 10. The fluid cooled, cutting tool system as defined in claim
2 9, further comprising a coolant return line, said coolant return
3 line extending between said at least one tool and said pump inlet,
4 for returning said coolant to said pump inlet after said coolant
5 exits said orifice means.

1 11. The fluid cooled, cutting tool system as defined in claim
2 10, further comprising a coolant reservoir in said coolant return
3 line.

1 12. The fluid cooled, cutting tool system as defined in claim
2 11, further comprising a coolant catch pan between said at least
3 one tool and said coolant return line, said coolant catch pan
4 receiving said coolant exiting said orifice means and directing it
5 into said coolant return line.

1 13. The fluid cooled, cutting tool system as defined in claim
2 12, further comprising a coolant filter in said catch pan, to
3 remove impurities from said coolant exiting said orifice means
4 prior to directing said coolant into said coolant return line.

ABSTRACT OF THE DISCLOSURE

A programmable, variable volume and pressure, coolant system regulating the amount of coolant flow to a cutting tool by controlling the speed of a coolant pump, and is comprised of a fluid control unit and an electrical control panel. The fluid control unit includes a pump and a AC pump motor operatively connected thereto. The electrical control panel includes: a power supply; circuit breakers; a computer; a variable frequency drive; control relays; and a junction block for making electrical connections to the control panel. The computer receives signals from the tool and a pressure transducer, and is programmed with information concerning the total flow area of the coolant orifices. Using this information, the computer determines an ideal pump speed, and sends a control signal to the variable frequency drive which in turn determines the pump motor speed. The coolant supply system also includes: a coolant supply line for routing coolant from the pump to the tool; a catch pan for collecting recycled coolant from the tool; a filter for removing impurities from the used coolant; a reservoir for storing coolant; and a return line for routing the recycled coolant to the reservoir and from the reservoir to the pump inlet.

COMBINED DECLARATION AND POWER OF ATTORNEY

As the below named inventor, I hereby declare that:

My residence, post office address, and citizenship are as stated below next to my name.

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

PROGRAMMABLE, VARIABLE VOLUME AND PRESSURE, COOLANT SYSTEM

the specification of which is attached hereto unless the following box is checked:

☐ was filed on _____ as United States Application Serial Number or PCT International Application Number _____ and was amended on _____ (if applicable).

I hereby state that I have reviewed and understand the contents of the above-identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose information which is material to patentability as defined in 37 CFR § 1.56.

I hereby claim foreign priority benefits under 35 U.S.C. § 119(a)-(d) or § 365(b) of any foreign application(s) for patent or inventor's certificate, or § 365(a) of any PCT International application which designated at least one country other than the United States, listed below and have also identified below, by checking the box, any foreign application for patent or inventor's certificates, or PCT International application having a filing date before that of the application on which priority is claimed.

Prior Foreign Application(s)

Priority Not Claimed

_____ (Number)	_____ (Country)	_____ (Day/Month/Year Filed)	<input type="checkbox"/>
_____ (Number)	_____ (Country)	_____ (Day/Month/Year Filed)	<input type="checkbox"/>

I hereby claim the benefit under 35 U.S.C. § 119(e) of any United States provisional application(s) listed below.

_____ (Application Number)	_____ (Filing Date)
_____ (Application Number)	_____ (Filing Date)

I hereby claim the benefit under 35 U.S.C. § 120 of any United States application(s), or § 365(c) of any PCT International application designating the United States, listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States or PCT International application in the manner provided by the first paragraph of 35 U.S.C. § 112.

I acknowledge the duty to disclose information which is material to patentability as defined in 37 CFR § 1.56 which became available between the filing date of the prior application and the national or PCT international filing date of this application.

(Application Number)	(Filing Date)	(Status -- patented, pending, abandoned)
(Application Number)	(Filing Date)	(Status -- patented, pending, abandoned)

I hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and transact all business in the Patent and Trademark Office connected therewith.

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I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

Full Name of Sole or First Inventor: GREGORY S. ANTOUN

Signature: 

Date: 9/19/97 Country of Citizenship: U.S.A.

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VERIFIED STATEMENT (DECLARATION) CLAIMING SMALL ENTITY STATUS
(37 CFR 1.9(f) and 1.27(b))--INDEPENDENT INVENTOR

As the below named inventor, I hereby declare that I qualify as an independent inventor as defined in 37 CFR 1.9 (c) for purposes of paying reduced fees under section 41 (a) and (b) of Title 35, United States Code, to the Patent and Trademark Office with regard to the invention entitled below and in:

TITLE OF INVENTION

PROGRAMMABLE, VARIABLE VOLUME AND PRESSURE, COOLANT SYSTEM

 X the specification filed herewith.

I have not assigned, granted, conveyed, or licensed and am under no obligation under contract or law to assign, grant, convey or license, any rights in the invention to any person who could not be classified as an independent inventor under 37 CFR 1.9 (c) if that person had made the invention, or to any concern which would not qualify as a small business concern under 37 CFR 1.9 (d) or a nonprofit organization under 37 CFR 1.9 (e).

Each person, concern or organization to which I have assigned, granted, conveyed, or licensed or am under an obligation under contract or law to assign, grant, convey, or license any rights in the invention is listed below:

 X no such person, concern or organization

I acknowledge the duty to file, in this application or patent, notification of any change in status resulting in loss of entitlement to small entity status prior to paying, or at the time of paying, the earliest of the issue fee or any maintenance fee due after the date on which status as a small business entity is no longer appropriate. (37 CFR 1.29 (b)).

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements are made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code, and that such willful false statements may jeopardize the validity of the application, any patent issuing thereon, or any patent to which this verified statement is directed.

GREGORY S. ANTOUN
Name of First Inventor


Signature of First Inventor

Date 9/19/97

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IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

IN THE APPLICATION OF:

APPLICANT : GREGORY S. ANTOUN

SERIAL NO. : Unassigned ART UNIT: Unassigned

FILED : Herewith EXAMINER: Unassigned

FOR : PROGRAMMABLE, VARIABLE VOLUME AND PRESSURE, COOLANT SYSTEM

ASSISTANT COMMISSIONER FOR PATENTS
WASHINGTON, DC 20231

Sir:

ASSOCIATE POWER OF ATTORNEY AND APPOINTMENT OF AGENTS
37 C.F.R. 1.34(b)

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Please recognize as Associate Agents in this case:

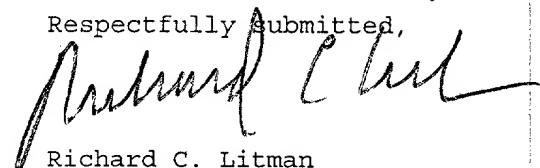
Dolph H. Torrence	Reg. No. 34,501
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The addresses and phone numbers of the above Attorneys and Agents are the same as that of the undersigned Principal Attorney.

All previous Associate Powers are hereby revoked.

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Respectfully submitted,



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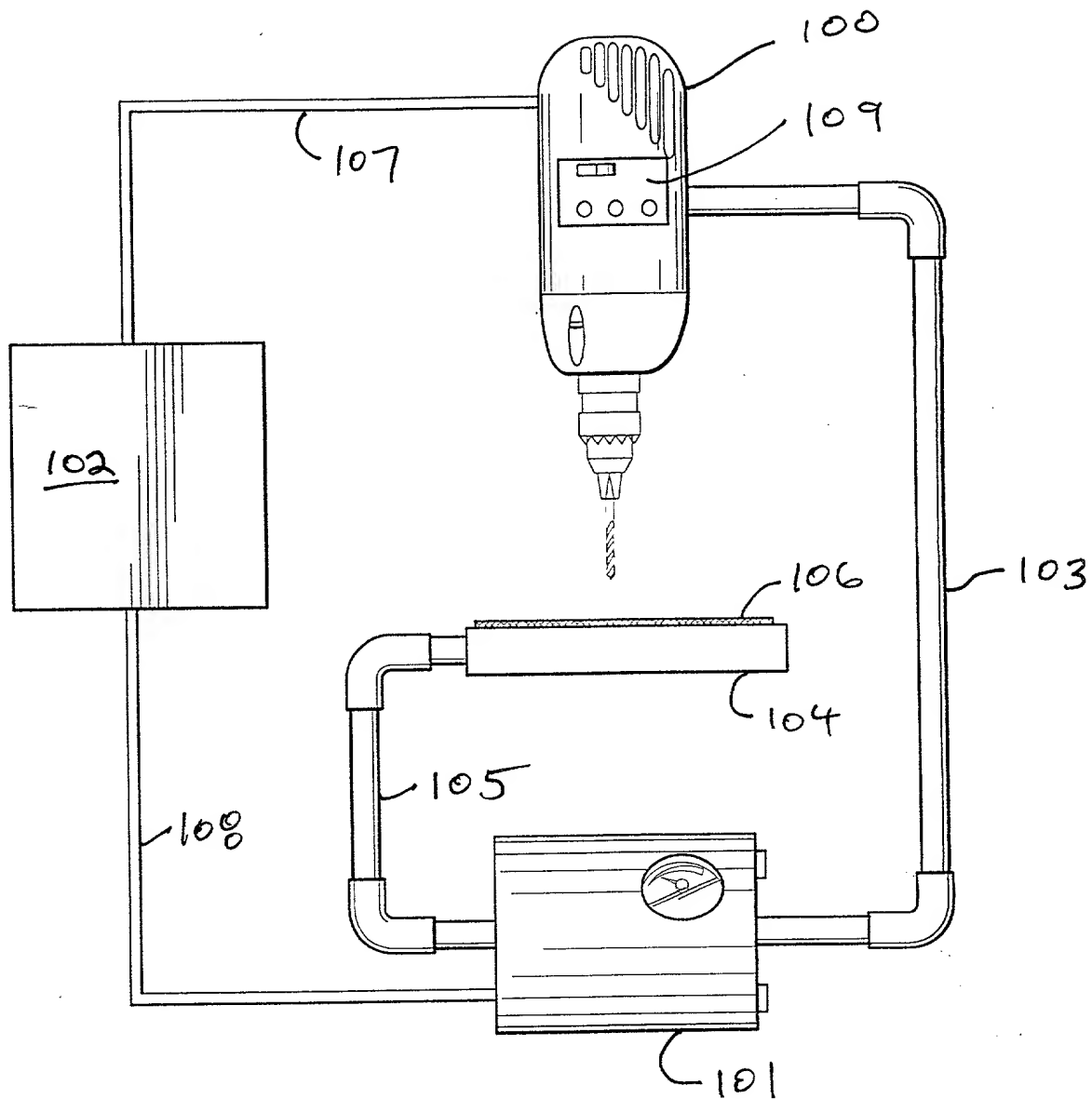


Fig. 1

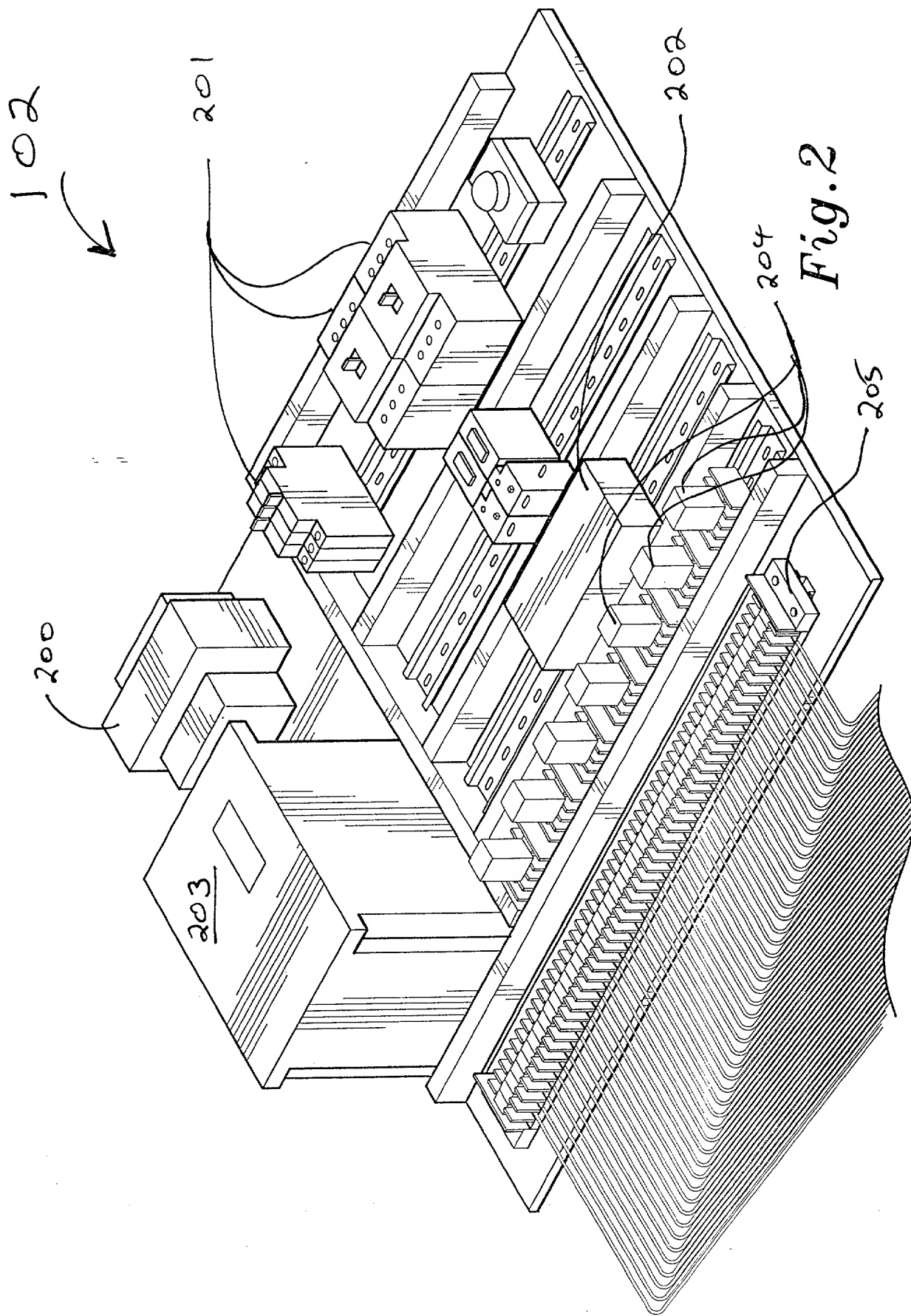


Fig. 2

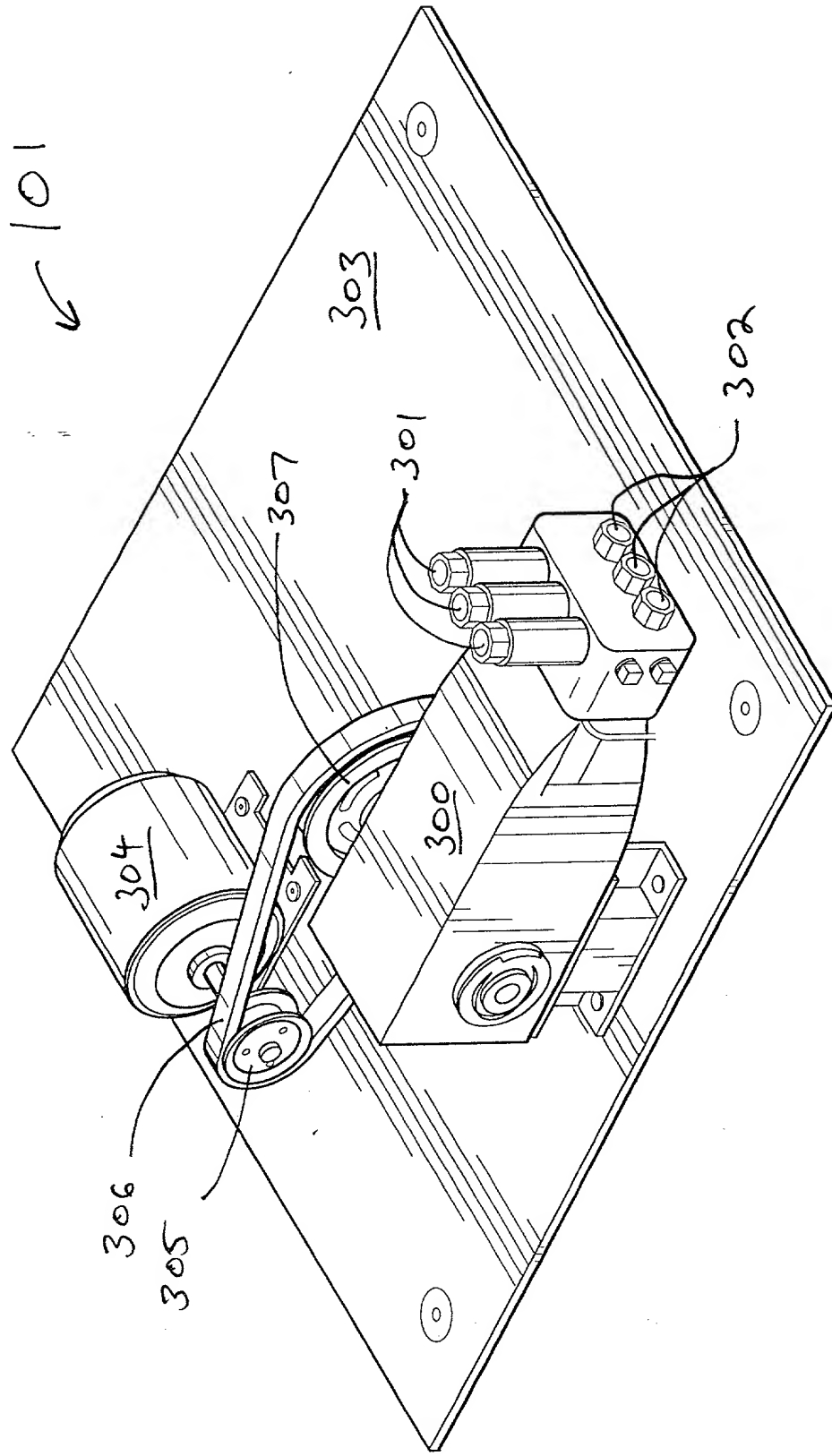
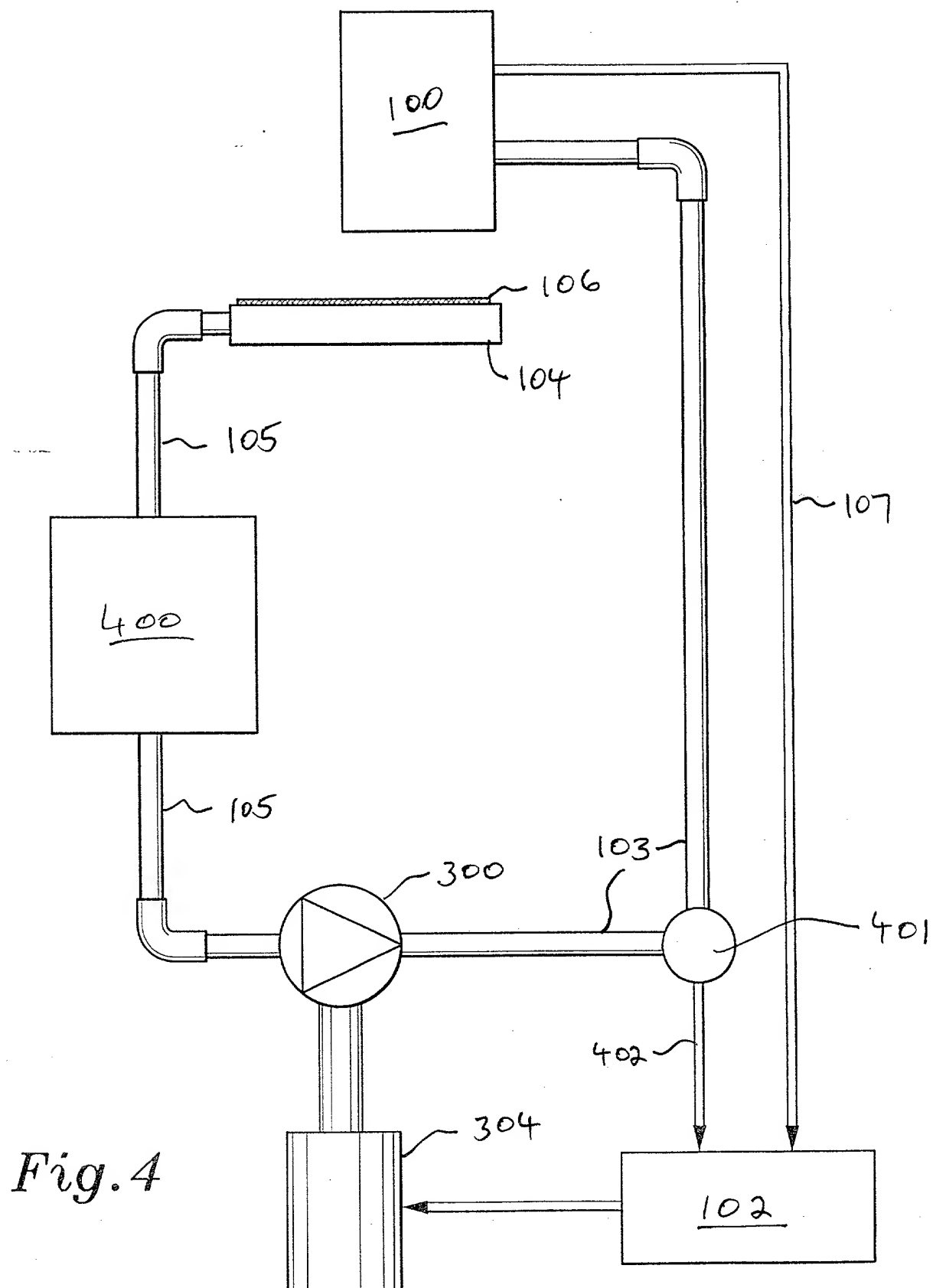


Fig. 3

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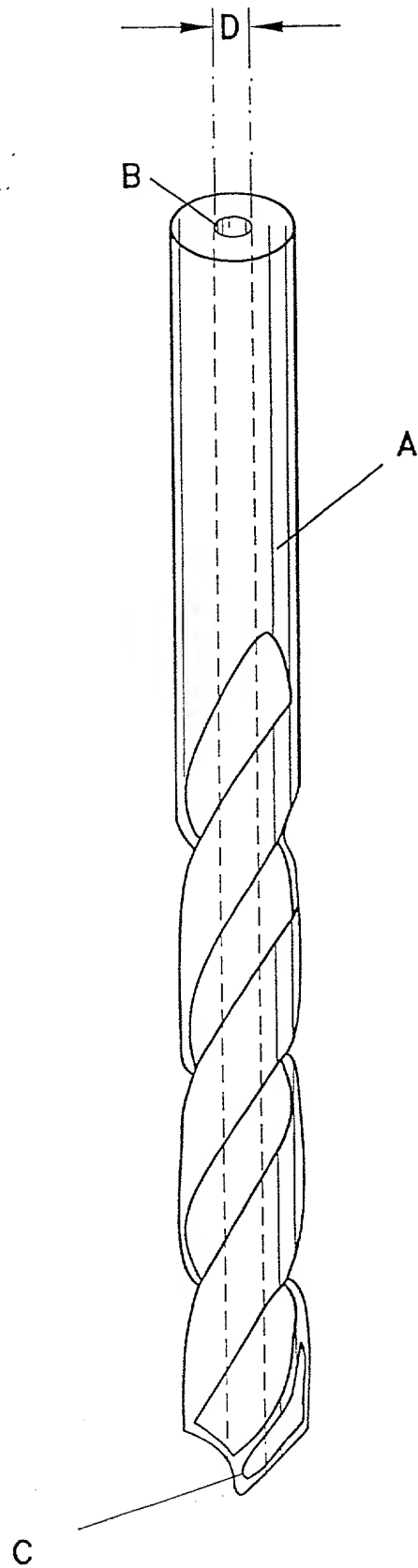


Fig. 5

(Prior Art)